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मानक

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Mazdoor Kisan Shakti Sangathan

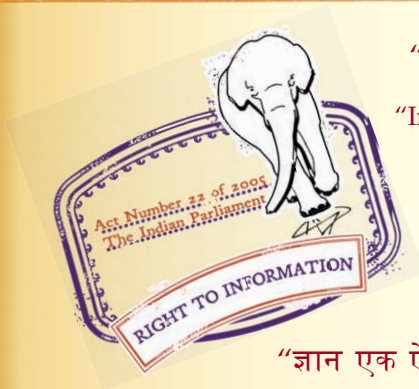
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“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 1244 (1990): Handloom cotton long cloth [TXD 8: Handloom and Khadi]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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IS 1244 : 1990
(Reaffirmed 2001)

भारतीय मानक

हथकरघे का सूती लट्ठा — विशिष्ट

(पहला पुनरीक्षण)

Indian Standard

**HANDLOOM COTTON LONG CLOTH —
SPECIFICATION**

(First Revision)

UDC 677.21.074.6L

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

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Price Group 2

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

This standard was first published in 1958, and is being revised to overcome difficulties encountered by the handloom industry in its implementation. Following are the important changes carried out while revising this standard:

- a) Use of cotton yarn conforming to IS 171 : 1985 has been specified.
- b) Constructional particulars have been modified taking into consideration present production patterns prevailing in the handloom industry.
- c) Only negative tolerances have been specified on ends/dm, picks/dm and mass g/m² to ensure minimum desirable construction. There being no tolerance on positive side on these requirements, it would provide flexibility to industry to adjust construction of the fabrics depending upon market demands.
- d) Breaking load requirement has been specified as optional requirement. This requirement has to be enforced in case it is not possible to establish that cotton yarn conforming to IS 171 : 1985 has been used.
- e) Tolerances on length and width have been adopted from the instructions issued by the Central Government under Trade and Merchandise Marks Act 1958 (43 of 1958) as given in Notification No. S.O. 2937, dated 20 September 1962.
- f) For determining the conformity of the cloth to the requirements laid down in this standard, a provision has been incorporated to allow testing of specimens in prevailing atmospheric condition. However, in all cases of disputes specimens shall be tested after conditioning in the standard atmospheric conditions.
- g) Provision has been incorporated for agreement between the buyer and the seller with respect to permissible number of defects in cotton long cloth.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

HANDLOOM COTTON LONG CLOTH — SPECIFICATION

(First Revision)

1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements for nine varieties of handloom cotton long cloth.

1.2 This standard does not specify the general appearance, feel, finish, etc.

2 REFERENCES

2.1 The Indian Standards listed at Annex A are necessary adjuncts to this standard.

3 ATMOSPHERIC CONDITIONS FOR TESTING

3.1 Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of handloom cotton long cloth to this standard. However, in all cases of dispute, specimen shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standard test methods.

4 YARN

4.1 The cotton yarn used shall conform to the requirements specified in IS 171 : 1985.

5 REQUIREMENTS

5.1 The long cloth shall conform to the requirements specified in Table 1.

5.1.1 However, breaking load requirement shall be an optional requirement. It shall be enforced only when conformance of cotton yarn to the requirements specified in IS 171 : 1985 is not known.

5.2 The long cloth shall also conform to the requirements specified in Table 2.

5.3 The long cloth shall be woven in plain weave.

5.4 Dimensions

Length and width of the long cloth when determined in accordance with IS 1954 : 1969 shall be as agreed to between the buyer and the seller or as declared by the seller subject to the tolerances specified in the Government of India, Ministry of Commerce and Industry Notification No. S.O. 2937 dated 20 September 1962 issued under Trade and Merchandise Marks Act 1958 (43 of 1958) (see Annex B).

Table 1 Constructional Particulars and Breaking Load Requirements for Handloom Cotton Long Cloth

(Clause 5.1)

Variety No.	Count of Yarn* Universal Count (Cotton Count)		Ends/dm	Picks/dm	Mass g/m ²	Breaking Load in Newton	
	Warp	Weft				Warp	Weft
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)
1	30 tex (20s)	30 tex (20s)	208	190	125	220	200
2	30 tex (20s)	30 tex (20s)	192	176	115	200	180
3	25 tex (24s)	25 tex (24s)	250	240	130	220	220
4	20 tex (30s)	20 tex (30s)	320	250	120	220	180
5	15 tex (40s)	20 tex (30s)	270	220	90	200	160
6	15 tex (40s)	15 tex (40s)	350	280	100	280	200
7	35 tex (17s)	35 tex (17s)	144	128	200	380	300
8	30 tex (20s)	42 tex (14s)	144	128	145	360	160
9	15 tex (40s)	23 tex (26s)	144	160	85	300	160
Tolerance percent	—	—	— 5	— 5	— 5	— 5 on Average value and — 15 on Individual reading	
Method of test	—	—	IS 1963 : 1981		IS 1964 : 1970 or Annex D		IS 1969 : 1985

*For guidance only.

5.5 In order to illustrate or specify the indeterminate characteristics, such as general appearance, lustre, feel and shade, if a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

5.5.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 INSPECTION

6.1 The long cloth when visually inspected should be free from the major flaws listed at Annex C.

6.1.1 The number of permissible major flaws per unit length shall be as agreed to between the buyer and the seller.

6.2 For details of the flaws mentioned in 6.1 a reference may be made to IS 4125 : 1987.

7 MARKING

7.1 The long cloth shall be suitably marked with the following information:

- Name of the material and variety No.,
- Length (m) and width (cm), and
- Indication of the source of manufacture.

7.1.1 The long cloth may also be marked with the Standard Mark, the details for which may be obtained from the Bureau of Indian Standards.

8. PACKING

8.1 Unless otherwise agreed upon by the buyer and the seller the long cloth shall be preferably packed in bales or cases in conformity with the procedure laid down in IS 1347 : 1972 or IS 293 : 1980.

9 SAMPLING

9.1 Lot

The quantity of the long cloth of the same variety delivered to one buyer against one despatch note shall constitute a lot.

9.2 The conformity of the lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from the lot.

9.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with Table 3.

9.3.1 For selection of samples at random from the lot, procedure given in IS 4905 : 1968 may be followed.

Table 2 Other Requirements for Handloom Cotton Long Cloth
(Clause 5.2)

Sl No.	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
i)	Dimensional change, percent, <i>Max</i>	4	IS 2977 : 1989
ii)	Scouring loss percent, <i>Max</i>	2.5	IS 1383 : 1977
iii)	pH value of the aqueous extract	6.0 to 8.5	IS 1390 : 1983
iv)	Colour fastness:		
a)	Light	4 or better	IS 686 : 1985 or IS 2454 : 1985
b)	Washing : Test 4		IS 765 : 1977
	i) Change in colour	4 or better	
	ii) Staining on fabric	4 or better	
c)	Perspiration		IS 971 : 1983
	i) Change in colour	4 or better	
	ii) Staining on fabric	4 or better	

Table 3 Sample Size and Permissible Number of Non-conforming Pieces
(Clause 9.3)

Lot Size	Sample Size	Permissible Number of Non-conforming Pieces	Sub-sample Size
(1)	(2)	(3)	(4)
Up to 25	3	0	2
26 to 50	5	0	2
51 to 150	8	0	3
151 to 300	13	1	3
301 to 500	20	1	5
501 to 1 000	32	2	5
1 001 and above	50	3	8

9.4 Number of Samples and Criteria for Conformity

It shall be as follows:

Characteristics	Number of Samples	Criteria for Conformity
Ends, picks, mass, length, width and visual inspection	According to col 2 of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in col 3
Dimensional change, colour fastness, scouring loss, pH value and breaking load	According to col 4 of Table 3	All the test pieces shall meet the requirement

ANNEX A

(Clause 2.1)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
171 : 1985	Cotton and cotton regenerated cellulosic fibre blended grey yarn (<i>third revision</i>)	1954 : 1969	Methods for determination of length and width of fabrics (<i>first revision</i>)
293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
686 : 1985	Methods for determination of colour fastness of textile materials to daylight (<i>first revision</i>)	1964 : 1970	Methods for determination of weight per square metre and weight per linear metre of fabrics (<i>first revision</i>)
765 : 1979	Method for determination of colour fastness of textile materials to washing : Test 4 (<i>second revision</i>)	1969 : 1985	Methods for determination of breaking load and elongation of woven textile fabrics (<i>second revision</i>)
971 : 1983	Method for determination of colour fastness of textile materials to perspiration (<i>first revision</i>)	2454 : 1985	Methods for determination of colour fastness of textile materials to artificial light (xenon lamp) (<i>first revision</i>)
1347 : 1972	Inland packaging of cotton cloth and yarn (<i>first revision</i>)	2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (<i>first revision</i>)
1383 : 1977	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>first revision</i>)	4125 : 1987	Glossary of terms pertaining to defects in fabrics (<i>first revision</i>)
1390 : 1983	Methods for determination of pH value of aqueous extracts of textile materials (<i>first revision</i>)		

ANNEX B

(Clause 5.4)

**EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF COMMERCE
AND INDUSTRY (TRADE AND MERCHANDISE MARKS ACT 1958)
NOTIFICATION NO S.O. 2937 DATED 20 SEPTEMBER 1962**

1. A trade description of length stamped on grey, bleached, mercerized or coloured cotton piece goods:
 - i) in pieces stamped as of length 9 metres and below, the stamped length shall not exceed the actual length by more than 1 percent of the piece length or 7.5 cm, whichever is less, and;
 - ii) in pieces stamped as of length above 9 metres, the stamped length shall not exceed the actual length by more than 0.6 percent of the piece length or 7.5 cm, whichever is higher.
- Provided that the average length of the pieces in question shall not be less than the stamped length.
2. A trade description of width stamped on grey, bleached, mercerized or coloured cotton piece goods:
 - i) in pieces stamped as of width 102 cm or below, the stamped width shall not exceed the actual width at any point by more than 1.3 cm.
 - ii) in pieces stamped as of width over 102 cm up to 152 cm the stamped width shall not exceed the actual width at any point by

more than 1.25 percent of the stamped width of the piece.

- iii) in pieces stamped as of width 152 cm and above, the stamped width shall not exceed the actual width at any point by more

than 1.25 percent of the stamped width of the piece or 2.5 cm whichever is less.

Provided that average width of the piece in question shall not be less than the stamped width.

ANNEX C

(Clause 6.1)

LIST OF MAJOR FLAWS

One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm, or prominently noticeable double end running throughout the piece.

Undressed snarls noticeable over a length exceeding 5 percent of the length of the piece.

Smash, definitely rupturing the texture of the fabric.

Hole, cut or tear.

Reed marks prominently noticeable over a length exceeding 5 percent of the piece.

Defective or damaged selvedge noticeable over a length exceeding 5 percent of the length of the piece.

Skewing of more than three percent on weft.

Weft crack or two or more missing picks across the width of the fabric.

Warp or weft bar due to the difference in raw material, count, twist, lusture, colour, shade or spacing of adjacent groups of yarns (starting mark).

More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm.

Noticeable warp or weft float in the body of the fabric.

Noticeable oil or other stain in the fabric.

Oily weft in the fabric.

Prominently noticeable slub.

Conspicuous broken pattern.

Gout due to foreign matter, usually lint or waste woven into the fabric.

Prominent selvedge defect.

Significant shading or listing in fabrics having a gradual change in tone or depth of shade of fabric (excluding selvedge or border running parallel to the selvedge).

Coloured flecks.

Blurred or dark patch.

Patchy, streaky or uneven dyeing.

Dye bar.

Fuzzy appearance.

ANNEX D

(Table 1)

METHOD FOR DETERMINATION OF MASS OF FABRIC

D-1 Cut four specimens of 100 mm × 100 mm from a sample. Condition all the specimens in the desiccator charged with saturated solution of sodium nitrate at $27^{\circ} \pm 2^{\circ}\text{C}$ for a period of 24 hours. Remove all the specimens from the

desiccator and immediately determine their collective mass in weighing balance to the nearest milligram.

D-2 Calculate mass of fabric in g/m².

Standard Mark

The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

Bureau of Indian Standards

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